

Work Order ID 67999

Tuesday, April 05, 2011 10:48:05 AM

**PRELIMINARY
ISSUE**



Page 1

Item ID: D4380-25

Accept



Setup Start



Revision ID: PRELIM

Item Name: Cover, Cabin Light

Stop



Start Date: 4/5/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 5.00

Customer:

~~PRELIMINARY ISSUE~~

Reference:

Approvals: Process Plan: *MF*

Date: *11-04-05*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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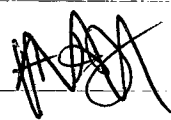
Draw Nbr

Revision Nbr

D4380

PA6

PA2 BB



0.00

100



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

5

BB
11/04/05

105



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QS1022 Kydex

Temp: *150*

Time IN: *6:00 PM*

Time OUT: *7:00 AM*

11/04/04
11/04/04

5

BB
11/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Work Order ID 67999

Tuesday, April 05, 2011 10:48:05 AM



Page 3

Item ID: D4380-25
Revision ID: PRELIM
Item Name: Cover, Cabin Light

Accept



Setup Start



Stop



Start Date: 4/5/2011 Start Qty: 5.00
Required Date: 4/5/2011 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 		0.00							
Hand Thermo	Memo	0.00				5			11/04/05
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150 	QC2- Inspect parts off machine FAI/FAIB	0.00				5			11/04/05
QC	Memo	0.00							
Quality Control	Complete FAI document								
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

- inspected to Pat

Don only

Subtotal

(15)

W/O:		WORK ORDER CHANGES					
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Work Order ID 67999

Tuesday, April 05, 2011 10:48:05 AM



Page 4

Item ID:	D4380-25	Accept		Setup	Start	
Revision ID:	PRELIM					
Item Name:	Cover, Cabin Light				Stop	
Start Date:	4/5/2011	Start Qty: 5.00				
Required Date:	4/5/2011	Req'd Qty: 5.00				
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 Packaging Packaging	Identify as per dwg & Stock Location <i>FAKE</i> Memo	0.00 0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

RD2370

POSITIVE RECALL

EFFECTIVE *4/24/05*

RELEASED *[Signature]*

AUTH *[Signature]*

DATE *[Signature]*

mf

11-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:48:02 AM

Page 1

Work Order ID: 67999

Parent Item: D4380-25

Parent Item Name: Cover, Cabin Light



Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: Rev. A New Issue 11/04/04 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	3.46875	17.34375			



6185 KYDEX .080"



Location

Loc Qty

Loc Code

therm

787.2912

787.2912

116576

17.34375 eq BL

DL
11/04/04

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 67999
Description: COVER CABIN LIGHT		Part Number: DY380-25
Inspection Dwg: 4300-25 Rev: PA8		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB	Date: 11/04/05
------------------------	-----------------------

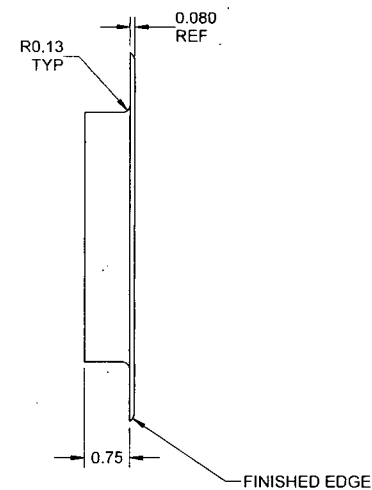
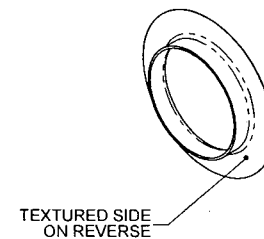
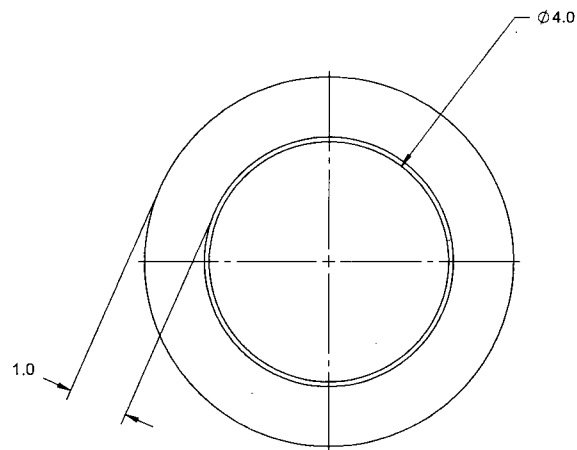
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.0	± 0.10	3.95	✓		TH-01 vern	
1.0	± 0.100	1.01	✓		TH-01 vern	

Measured by: BB	Date: 11/04/05
Audited by: S to PA7 Dm on ly	Date: 11/04/06
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



D4380-25 COVER, CABIN LIGHT

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM -25 PART PER MOULD DT9747.
TRIM PER MOULD LEAVING FINISHED EDGE.

PRELIMINARY ISSUE
DL 11.04.05

DESIGN	<i>DL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DL</i>		
CHECKED		DRAWING NO. D4380	REV. PA7 SHEET 13 OF 19
MFG. APPR.		TITLE CEILING POCKETS	SCALE NTS
APPROVED		<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.			
DATE	11.04.05		

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NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Saturday, April 02, 2011 5:44 PM
To: 'Daryl Leger'
Cc: 'Eric Charbonneau'; 'JEANLUC MENARD'; 'Linda Lacelle'; Bill Beckett; 'Harvey Siemens';
'David Shepherd'
Subject: D4380 Issues

Hi Daryl,

Please see D4380-PA6 in the Prelim folder.

Fortunately, the guys were still here and I talked to them about the manufacturing issues.

Based on their feedback, I have modified the D4380-17 cover. It should be a little easier to manufacture.

However, the -3/-5/-27/-29 need to stay as they are. Please use the "cheat the corners" technique to make the part as true to the drawing as possible. There are spare air conditioning vents here – we could fedex you one on Monday if that would help in creating the moulds.

The only thing I changed in the PA6 rev was the -17.

As for cutting out the "tops" of the round parts (-21/-23/-25 etc), it is up to you. If you would like to cut it out and trim it, that's ok, or the guys here can do that.

Thanks Daryl,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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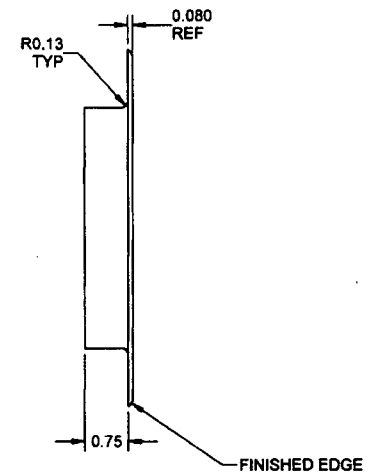
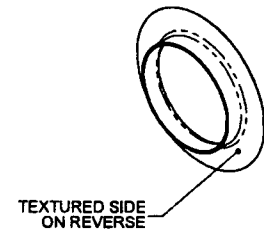
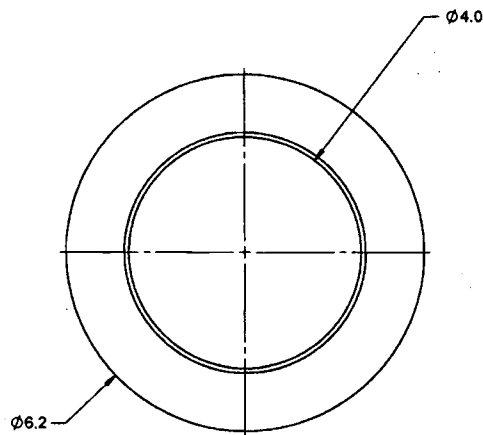
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D4380-25 COVER, CABIN LIGHT

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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 0.10 lbs
- 8) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040
- 9) TOOLING: THERMOFORM PER MOULD DT9747 AND DART QSI 022
- 10) TRIM PER MOULD LEAVING FINISHED EDGE

RELEASED
2011-05-10
JMS

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. A
MFG. APPR.	BC	D4380	SHEET 13 OF 19
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	CEILING POCKETS	NTS
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